



Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC
V8A 0G3, 604-483-AERO (2376)

Quantity:	2
PN:	84267-01
Description:	Cargo Basket Handle Bracket
Supplier:	Aero Design
PO#:	
WO#:	2014-48



Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC
V8A 0G3, 604-483-AERO (2376)

Quantity: 1

PN: 36280-01

Aircraft: All

Model: All

Description: Lid Prop


Supplier: Aero Design

Color:

WO#: 2014-28

PO#

[illegible]

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No.	
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3					5. Work Order/Contract/Invoice WO 2014-55	
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work	
	Long Cargo Basket	78410-01	1	78401-51	New	
12. Remarks Modified with walkway on lid and front end cutout on LH side IAW DCL704, Black						
13a. Certifies that the items identified above were manufactured in conformity to:			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12 Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.			
<input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.						
13b. Signature 		13c. Approved Organization Number AMF 73-04		14b. Signature		14c. Approved Organization Number
13d. Name Jeff Clarke - AD02		13e. Date (dd/mmm/yyyy) 22 July 2014		14d. Name		14e. Date (dd/mmm/yyyy)
<p style="text-align: center;">Installer Responsibilities</p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>						

CLARKES HOME

CARGO BASKET BODY FABRICATION - COMMON

2014-55

AS350 long
LH Cutout

General

These instructions apply to all cargo basket body assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

Bell 206L/407 – Right side only

69811, Revision 3 – Standard Low Mounted Basket

94511, Revision 0 – Extra-Wide Low Mounted Basket

94611, Revision 0 – Extra-Wide Low Mounted Ski Basket

76611, Revision 0 – High Mounted Ski Basket

Options 70404, Revision 2 – Front end cutout – 698

70411, Revision 0 – Front end cutout – 945/946

Eurocopter AS350/AS355 – left or right

77611, Revision 1 – Short Basket

76411, Revision 3 – Medium Basket (left or right)

→ 78411, Revision 2 – Long Basket

94011, Revision 0 – Extra Large (ski) Basket

→ *Options* 70406, Revision 2 – Front end cutout – 764/776/784/940

Robinson R44 – left or right

90611, Revision 0 – Standard Basket (left or right)

Bell 206B – right side only

80211, Revision 0 – Short Basket

80311, Revision 0 – Medium Basket

81111, Revision 0 – Long Basket

Options 70406, Revision 2 – Front end cutout – 802/803/811

Bell 429 – right or left

95911, Revision 0 – Standard Basket

Bell Medium – left or right

75111, Revision 0 – Standard Basket

95511, Revision 0 – Extra Large (ski) Basket

Options 70407, Revision 1 – Front end cutout – 751

704, Revision – Front end cutout – 955

MD600

82811, Revision 0 – Standard Basket

Options – Applicable to all models

70403, Revision 5 – Auxiliary Latch

CARGO BASKET BODY FABRICATION - COMMON

Complete
(initial or SCA #)

Work Order: 2014-55

Date Open: 17 JUNE 2014

1. Rim Assembly – Basket Body

ADOL

- a. Cut and fit $\frac{3}{4}$ " x 0.035 material to fit rim jig.
 - i. 1 or 2 lid prop bushing holes in short tube – refer to drawing
- b. Record material PO on attached material list.
- c. Remove writing on tubes with acetone and scotch bright.
- d. For extra large baskets – drill #30 (0.129) vent holes to vent stringer tubes into rims.
- e. 94611 (206L/407 XL ski) only – drill for 4 threaded bushings before assembling rim.

2. Weld Rim Assembly.

AD-05

- a. Record welding rod PO on attached material list.
- b. 94611 (206L/407 XL ski) only – weld 4 threaded bushings into inboard rim tube.

3. Inspection

ADOL

- a. Rim for complete welds

4. Frame assembly – body

ADOL

- a. General
 - i. Vent holes shall be #30 (0.129), and located inside the structure wherever possible to allow venting of weld gasses through existing holes (i.e. lid prop bushing, hoops, etc.)
- b. Grind corner welds from step 2 on rim to allow hoops to sit flat.
- c. Pull required hoops from stock - standard, attachment, handle.
 - i. If hoops are not in stock see detailed procedure sheet for specific hoop fabrication.
 - ii. Ensure vent hole is located at centre of tube to vent spine tubes.
- d. Assemble hoops with attachment lug locating jig and hoop spacing jig.
 - i. Ensure correct order and orientation of hoops. Refer to drawing.
 1. Attachment lugs are on inboard side.
 2. Handle bracket bushings are on outboard side, second hoop from both ends.
May be on attachment hoops.
 - ii. Run 3/8-24 tap into attachment lugs to ensure clear threads.
 - iii. Bolt attachment lug locating jig to attachment hoops with 3/8-24 bolts.
 - iv. Attach inboard and outboard hoop spacing jigs to all hoops using 1" C-clamps. Raise jigs approximately 2" off table to allow room to weld around hoops.
 - v. Attach bottom (spine) jig to all hoops using 1" C-clamps along the centre line of the basket. Ensure jig is straight prior to tightening all clamps.
- e. Cut $\frac{1}{2}$ " x 0.035 material to fit spine jig.
- f. Cut $\frac{1}{2}$ " x 0.035 material for strut to fit from lower inboard attachment to upper outboard rim.
 - i. Refer to applicable drawing for position, not required on some baskets.
- g. Option: Cut $\frac{1}{2}$ " x 0.035 material for front end cutout. Record material PO on attached material list.
- h. 90611 (R44) only: Cut $\frac{1}{2}$ " x 0.035 material to fit front end structure. Record material PO on attached material list.
- i. Drill vent holes into attachment hoop and/or rim to vent strut(s) and front end cutout.

- j. Record hoop WOs and material POs on attached material list.
- k. Remove writing on tubes with acetone and scotch bright.
- l. Insert rim assembly into jig and set frame assembly onto rim. Ensure correct orientation of lid prop bushings in rim to frame. Bushing hole must be closer to attachment side.
- m. Align hoops to rim in accordance with drawing. General positions:
 - i. Extra large baskets
 - 1. inboard side of hoops (attachment side) aligns to OUTSIDE of rim
 - 2. outboard side of hoops (handle side) aligns to INSIDE of rim
 - 3. forward and aft hoops align to INSIDE of rim
 - ii. All other baskets
 - 1. inboard side of hoops (attachment side) aligns to INSIDE of rim
 - 2. outboard side of hoops (handle side) aligns to INSIDE of rim
 - 3. forward and aft hoops align to INSIDE of rim, except R44

5. TIG weld frame to rim assembly.

- a. Ensure lug locating jig and hoop locating jigs are in place. Jigs must remain in place for as long as practical during welding.
- b. Strut tubes and front end cutout (see step 4.f. and g.) must be welded in place after the hoops are welded to the rim. Jig(s) must be in place prior to welding strut tubes.
- c. Robinson R44 (90611) requires fitting and welding of forward end after remainder of basket frame is welded. Use jig to support front hoop.
- d. Record welding rod PO on attached material list.

6. Inspection

- a. Frame assembly for complete welds.

7. Mesh assembly.

- a. Pull sheet of expanded mesh from stock. Record material PO on attached material list.
- b. Cut mesh to size for body.
- c. Remove surface rust with scotch-brite.
- d. Bend body mesh – use table with bend markings on top. Lock wheels on table.
 - i. For extra wide baskets only –
 - 1. Set $\frac{3}{4}$ " angle along edge of table under mesh sheet. Set 1.5" square tube on top of mesh aligned with angle on edge of table. Clamp in place with 6" C-clamps.
 - 2. Bend upper edge of sheet just past a cell intersection to make a flange 2.5" - 3.25" wide. Closer to 2.5" is preferred, full cell intersection on flange side at bend is required.
 - 3. Bend down by hand as far as possible, then use a hammer to flatten the bend tight against the angle on the edge of the table.
 - ii. Using markings on table, align sheet to indicated edge.
 - iii. Using markings on table, align 3" tube to required position and clamp tube in place.
 - iv. Bend mesh by hand tightly over tube along length of tube.
 - v. Keeping mesh in place, un-clamp 3" tube, move to other position and clamp tube in place.
 - vi. Bend mesh by hand tightly over tube along length of tube.
- e. Install attachment lug jig onto basket frame.

- f. Ensure end struts are welded in basket frame if required by the drawing.
- g. Insert mesh into basket.
 - i. General
 - 1. Some cells may interfere with correct positioning, especially at the upper corners and around struts. Bend cell(s) in as required, do not cut cells off.
 - 2. Ideally welds will be located on mesh intersections. Shift mesh if possible to minimize welds located off mesh intersections.
 - 3. Ensure mesh reaches all edges of basket BEFORE trimming. Regardless of progress in clamping, remove clamps and shift mesh if required.
 - 4. Ensure cleco clamps are placed from the inside of the basket to allow removal during welding. Cleco clamps may be used from the outside during fitting, but must be removed prior to welding.
 - ii. Extra large baskets only – seat corner of mesh with flange into inboard upper corner of frame. Use C-clamps on edge of flange as required to maintain tight fit.
 - iii. Starting at inboard top edge of basket, clamp mesh to hoop near top rim using cleco clamps onto hoops. For regular size baskets, edge of mesh should sit approximately half way up rim tube.
 - iv. Working down the inboard side, clamp mesh to hoops with cleco clamps. Clamp down into radius of hoop and continue clamping as required to maintain tight fit in corner of hoop. After the corners are tight, two clamps just onto the radius on both ends should be sufficient to hold the corner tight, remove all extra clamps.
 - v. Clamp mesh to spine in at least 1 place per section.
 - vi. Working up the outboard side, clamp the mesh into the radius of hoop and continue clamping as required to maintain tight fit in corner of hoop. After the corners are tight, 2 clamps just onto the radius on both ends should be sufficient to hold the corner tight, remove all extra clamps.
 - vii. Trim upper outboard edge of mesh if required, edge of mesh must be low enough on rim tube to prevent the weld from protruding above the edge of the rim. Some sheets are tapered and may require ½ to 1 cell to be removed over some or all of the length of the basket. De-burr cut edges with a sanding disc on a die-grinder. Straighten cut cells with duck-bill pliers. Clamp mesh near upper edge to hoops with cleco clamps after trimming.
 - viii. Trim ends to land on hoops, at mesh intersections if possible.
- h. Cut mesh to fit ends. Record material PO on attached material list.
 - i. Remove surface rust with scotch-brite.
 - ii. Ensure mesh is cut at intersections where possible.
 - iii. Bend top edge of mesh 1/8"-3/16" down at 45 degrees
 - iv. Cut for front end cutout if required.
- i. 90611 (R44) only: Cut mesh to fit upper forward end. Record material PO on attached material list.
 - i. Remove surface rust with scotch-brite.
 - ii. Ensure mesh is cut at intersections where possible.
 - iii. Bend top edge of mesh 1/4" down at 60 degrees.
 - iv. Fit mesh to front end of basket.

CARGO BASKET BODY FABRICATION - COMMON

Complete
(initial or SCA #)

AD-05

8. Weld mesh to frame assembly per drawing.
 - a. Ensure lug locating jig is in place prior to welding.
 - b. General welding requirements for all baskets, MIG welding:
 - i. Every intersection at top edges.
 - ii. Every intersection at ends.
 - iii. First 5 intersections down on hoops, then every second intersection.
 - iv. Every intersection along spine.
 - v. Extra large baskets – every intersection along corner.
 - vi. Every intersection around ends
 - vii. Every intersection along struts (if applicable)
 - c. Bend and trim cells bent in to fit mesh as required and weld in position.
 - d. Grind high spots off body mesh welds on ends before welding end mesh.
 - e. 90611 (R44) only – weld lid prop bushing (step 9) into rim BEFORE welding upper mesh on forward end of basket assembly.
 - f. Record welding rod PO on attached material list.

9. Weld basket components

- a. TIG weld lid prop bushing(s), one or two per drawing.
 - i. Record welding rod PO on attached material list.
 - ii. Record lip prop bushing WO on attached material list.
- b. TIG weld caps to close top of 1" hoops as applicable.
- c. 94611 (Bell206L/407 XL ski) only: cut rim over cross tube gap.
 - i. Cut inboard rim on aft end. Grind flush with hoops.
 - ii. TIG weld caps on open tubes.
 - iii. Record cap material PO on attached material list.
- d. 95911 (Bell 429) only: placard bracket to forward upper corner of basket.
 - i. Record welding rod PO on attached material list.
 - ii. Record placard bracket WO on attached material list.

AD-05

10. Clean up

- a. Grind high spots off mesh welds.
- b. Tighten mesh using special pliers. Tighten enough to remove "oil canning", where mesh springs in or out. Do not tighten in corners of hoops, mesh will be deformed.
- c. Drill #9 through lid prop bushing(s). De-burr hole(s).
- d. Remove surface rust with scotch-brite pad.

OK

11. Final Inspection

To be completed by a different person than the previous steps.

- a. Basket body assembly for complete welds, and required minimum mesh weld locations.
- b. Filled vent holes – usually on hoops
- c. Overall condition and conformity to drawing(s).
 - i. Hoops for height.
 - ii. Rim for width and length and alignment.
 - iii. Lid prop lugs in correct ends.
 - iv. Fore/aft strut in hoop if required by drawing.
- d. Material lists complete.

OK

CARGO BASKET BODY FABRICATION - COMMON

Complete
(initial or SCA #)



- e. Tag complete basket body assembly in preparation for powder coating.

12. Powder Coating

- a. Parts are to be powder coated white in accordance with commercial practices.
- b. Record powder coating PO.
- c. Inspect powder coating on receiving.
- d. Tag basket body assembly and place into stock in preparation for assembly.

Work Order: 2014-55

Material Tracking Sheet
Eurocopter AS350 / AS355
Long Basket Body Fabrication

1 of 2

Date Opened: 17 JUNE 2014

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
			78411-01	Basket Assembly		
Step 1				<i>Rim Assembly</i>		
	. 2		--	3/4" Tube - Long Rim (93.25")	4130 Steel, 3/4" x 0.035 Sqr. Tube	14009
	. 2		--	3/4" Tube - Short Rim (22.5")	4130 Steel, 3/4" x 0.035 Sqr. Tube	12123
Step 2				<i>Weld Rim Assembly</i>		
	. A/R		--	Welding Rod	ER70S-2 TIG Rod	PO # 14005
Step 3				<i>Inspection - Rim</i>	None	
Step 4				<i>Frame Assembly</i>		
	. 4		76421-01	Hoop - standard	4130 Steel, 1/2" x 0.035 Sqr. Tube	2014-56
	. 2		76423-01	Attachment hoop (aft)		2014-29
	. 5		--	1/2" Tube - spine	4130 Steel, 1/2" x 0.035 Sqr. Tube	14009
Step 4.g.		70406	70406-01	Option: Front End Cutout		
			70406-03	1/2" Tube	4130 Steel, 1/2" x 0.035 Sqr. Tube	14009
			70406-04	1/2" Tube	4130 Steel, 1/2" x 0.035 Sqr. Tube	14009
Step 5				<i>Weld Frame Assembly</i>		
	. A/R		--	Welding Rod	ER70S-2 TIG Rod	PO # 14005
Step 6				<i>Inspection - Frame Assembly</i>	None	
Step 7				<i>Mesh Assembly</i>		
	. 1		--	Mesh (Body - 48" x 92.25")	3/4-16F Expanded Mild Steel sheet	14012
	. 2		--	Mesh (End - 22" x 17")	3/4-16F Expanded Mild Steel sheet	14012
Step 8				<i>Weld Mesh</i>		
	. A/R		--	Welding Rod	ER70S-6 MIG Wire	PO # 14005

Work Order: 2014-55Material Tracking Sheet
Eurocopter AS350 / AS355
Long Basket Body Fabrication

2 of 2

Date Opened: 17 JUNE 2014

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
Step 9				<i>Weld Basket Components</i>		
Step 9.a.	. 2		49215-01	Spacer (Lid prop)	304 Stainless Steel, 1/2" Dia.	WO# 2014-39
	. A/R		--	Welding Rod	ER308L TIG Rod	PO# 14028
Step 9.b.	. 2		--	Cap	1018 Mild Steel, 0.032" Sheet	PO# 9010
	. A/R		--	Welding Rod	ER70S-2 TIG Rod	PO# 14005
Step 10				<i>Clean Up</i>	<i>None</i>	
Step 11				<i>Inspection - Final Assembly</i>	<i>None</i>	
Step 12				<i>Powder Coating</i>		

CARGO BASKET LID FABRICATION - COMMON

2014-55

AS350 long w/walkway

General

These instructions apply to all cargo basket lid assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

Bell 206L/407 – Right side only

69812, Revision 3 – Standard Low Mounted Basket; Extra-Wide Low Mounted Basket

94612, Revision 0 – Extra-Wide Low Mounted Ski Basket

76612, Revision 0 – High Mounted Ski Basket

Eurocopter AS350/AS355 – left or right

77612, Revision 1 – Short Basket

69812, Revision 3 – Medium Basket (left and right)

→ 78412, Revision 2 – Long Basket

94012, Revision 0 – Extra Large (ski) Basket

Robinson R44 – left or right

90612, Revision 0 – Standard Basket (left or right)

Bell 206B – right side only

80212, Revision 0 – Short Basket

80312, Revision 0 – Medium Basket

81112, Revision 0 – Long Basket

Bell 429 – right or left

95912, Revision 0 – Standard Basket

Bell Medium – left or right

75112, Revision 0 – Standard Basket

95512, Revision 0 – Extra Large (ski) Basket

MD600

82812, Revision 0 – Standard Basket

Options

→ 70405, Revision 3 – Walkway

70402, Revision 1 – Lid Door

CARGO BASKET LID FABRICATION

Complete
(initial or SCA #)

Work Order: 2014-55

Date Open: 17 JUNE 2014

1. Rim Assembly – Basket Lid

- a. Cut and fit $\frac{3}{4}$ " x 0.035 material to fit rim jig, 45 degree ends.
 - i. 1 or 2 lid prop bushing holes in short tube – refer to drawing
- b. Record material PO on attached material list.
- c. Remove writing on tubes with acetone and scotch bright.

AD-01

2. Weld Rim Assembly

- a. Record welding rod PO on attached material list.

AD-05

3. Inspection

- a. Rim for complete welds

OK

4. Frame assembly – Lid

- a. General
 - i. Vent holes shall be #30 (0.129), and located inside the structure wherever possible to allow venting of weld gasses through existing holes (i.e. lid prop bushing)
- b. Insert rim from step 2 into jig.
- c. Cut and fit $\frac{3}{4}$ " x 0.035 material, 21" long, for lid cross members.
- d. Record material PO on attached material list.
- e. Remove writing on tubes with acetone and scotch bright.
- f. Drill vent holes into rim to vent cross members into rim.
- g. Locate cross members in lid rim. Refer to drawing for spacing of cross members. Clamp cross members with C-clamps to jig.

OK

5. Frame assembly – Lid with optional walkway modification

- a. Fit cross members to rim in accordance with step 4.
- b. Attach walkway jig with C-clamps. Ensure correct orientation of rim, refer to drawing.
- c. Cut $\frac{1}{2}$ " x 0.035 material for walkway stringers to fit between lid cross members. Record material PO on attached material list.
- d. Drill vent holes into cross members at walkway stringers.
- e. Align walkway stringers on walkway jig using cleco clamps near both ends of each stringer, and clamp stringer to jig using a C-clamp in the centre.

OK

6. Weld frame assembly.

- a. Record welding rod PO on attached material list.
- b. Jigs must remain in place for as long as practical during welding.

AD-05

7. Inspection

- a. Frame assembly for complete welds.

OK

CARGO BASKET LID FABRICATION

Complete
(initial or SCA #)



8. Mesh assembly.

Note: 95912 (Bell 429) does not have mesh. Skip to step 10.

- a. Pull sheet of expanded mesh from stock. Record material PO on attached material list.
- b. Cut mesh to size for lid.
- c. Remove surface rust with scotch-brite.
- d. Ensure lid is prepared for mesh on the correct side.

9. Weld mesh to frame assembly per drawing.

AD-05

- a. General welding requirements for all lids:
 - i. Every intersection on all edges.
 - ii. First 5 intersections along cross members, then every second intersection.
- b. MIG weld both short sides.
- c. Clamp lid over spacer at centre of lid to pre-tension mesh.
 - i. $\frac{3}{4}$ " for lids under 76"
 - ii. 1" (check) for lids over 76"
- d. Weld remainder of mesh as indicated in a.
- e. Record welding rod PO on attached material list.

10. Weld lid components.

AD-05

- a. Handle brackets, locate in accordance with drawing.
 - i. Standard location: $\frac{1}{4}$ " outside of last cross member on both ends.
 - ii. Record handle bracket WO and welding rod PO on attached material list.
- b. Lid prop bushing(s).
 - i. one or two in accordance with drawing.
 - ii. Record lip prop bushing WO and welding rod PO on attached material list.
- c. Placard bracket. – not installed on 95912 (Bell 429)
 - i. Locate on cross member to set bracket in centre bay of lid.
 - ii. Record placard bracket WO and welding rod PO on attached material list.



11. Clean up

- a. Grind high spots off mesh welds.
- b. Tighten mesh using special pliers. Tighten enough to remove "oil canning", where mesh springs in or out.
- c. Straighten lid using frame attached under welding table. Work carefully, avoid excessive force to prevent kinking rim tubes.
- d. Drill #9 through lid prop bushing(s). De-burr hole(s).
- e. Drill for lid bumpers using $\frac{1}{4}$ " (#3) centre drill.
 - i. 3 places for lids under 76"
 - ii. 4 places for lids over 76"
- f. Remove surface rust with scotch-brite pad.

12. Final Inspection

To be completed by a different person than the previous steps.

- a. Basket lid assembly for complete welds, and required minimum mesh weld locations.
- b. Material lists complete.
- c. Overall condition and conformity to drawing(s).



CARGO BASKET LID FABRICATION

Complete
(initial or SCA #)



13. Powder Coating

- a. Parts are to be powder coated white in accordance with commercial practices.
- b. Record powder coating PO.
- c. Inspect powder coating on receiving.
- d. Tag lid assembly and place into stock in preparation for assembly.

Work Order: 2014-55

Material Tracking Sheet
Eurocopter AS350 / AS355
Long Lid Fabrication

1 of 2

Date Opened: 17 JUNE 2014

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
			78412-01	Lid Assembly		
Step 1				<i>Rim Assembly</i>		
	. 2		--	3/4" Tube - Long Rim (93.25")	4130 Steel, 3/4" x 0.035 Sqr. Tube	14009
	. 2		--	3/4" Tube - Short Rim (22.5")	4130 Steel, 3/4" x 0.035 Sqr. Tube	1223
Step 2				<i>Weld Rim Assembly</i>		
	. A/R		--	Welding Rod	ER70S-2 TIG Rod	PO#14005
Step 3				<i>Inspection - Rim</i>	None	
Step 4				<i>Frame Assembly</i>		
	. 4		--	3/4" Tube - Cross Member (21")	4130 Steel, 3/4" x 0.035 Sqr. Tube	12123
Step 5		70405		<i>Option: Frame Assembly - with walkway</i>		
	. 8		--	1/2" Tube - walkway	4130 Steel, 1/2" x 0.035 Sqr. Tube	14009
Step 6				<i>Weld Frame Assembly</i>		
	. A/R		--	Welding Rod	ER70S-2 TIG Rod	PO#14005
Step 7				<i>Inspection - Frame Assembly</i>	None	
Step 8				<i>Mesh Assembly</i>		
	. 1		--	Mesh (lid - 92.5" x 22")	3/4-16F Expanded Mild Steel sheet	1412
Step 9				<i>Weld Mesh</i>		
	. A/R		--	Welding Rod	ER70S-6 MIG Wire	PO#14005

Work Order: 2014-55Material Tracking Sheet
Eurocopter AS350 / AS355
Long Lid Fabrication

2 of 2

Date Opened: 17 JUNE 2014

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
Step 10				<i>Weld Lid Components</i>		
	. 1	84262	84262-01	Upper Handle Bracket Assembly		<i>WO# 2014-38</i>
	. . 4		36273-01	Lid Bracket	321 Stainless, 0.050 Sheet	
	. . 2		36275-02	Support	304 Stainless, 5/16" Rod	
	. A/R		--	Welding Rod	ER308L TIG Rod	<i>PO# 14028</i>
	. 2		49216-01	Spacer (Lid prop)	304 Stainless, 1/2" Dia.	<i>WO# 2014-09</i>
	. A/R		--	Welding Rod	ER308L TIG Rod	<i>PO# 14028</i>
	. 1		36204-10	Placard Bracket	1018 Steel, 0.035" Sheet	<i>WO# 2014-18</i>
	. A/R		--	Welding Rod	ER70S-2 TIG Rod	<i>PO# 14005</i>
Step 11				<i>Clean Up</i>		
Step 12				<i>Inspection - Final Assembly</i>		
Step 13				<i>Powder Coating</i>		

2014-55

BLK ASTAR LONG w/ cut out

CARGO BASKET ASSEMBLY - COMMON

General

These instructions apply to all cargo basket assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

Bell 206L/407 – Right side only

69810, Revision 3 – Standard Low Mounted Basket
94510, Revision 0 – Extra-Wide Low Mounted Basket
94610, Revision 0 – Extra-Wide Low Mounted Ski Basket
76610, Revision 0 – High Mounted Ski Basket

Eurocopter AS350/AS355 – left or right

77610, Revision 1 – Short Basket
76410, Revision 3 – Medium Basket (left or right)
78410, Revision 2 – Long Basket
94010, Revision 0 – Extra Large (ski) Basket

Robinson R44 – left or right

90610, Revision 0 – Standard Basket (left or right)

Bell 206B – right side only

80210, Revision 0 – Short Basket
80310, Revision 0 – Medium Basket
81110, Revision 0 – Long Basket

Bell 429 – right or left

95911, Revision 0 – Standard Basket

Bell Medium – left or right

75111, Revision 0 – Standard Basket
95511, Revision 0 – Extra Large (ski) Basket

MD600

82811, Revision 0 – Standard Basket

Options

70405, Revision 3? – Lid Walkway

CARGO BASKET ASSEMBLY - COMMON

Complete
(initial or SCA #)

Work Order: 2014-55

Date Open: _____

1. Lid Assembly

ADOG

- a. Install lid bumpers on bottom.
 - i. Fill bumper holes with RTV silicone sealant.
 - ii. Insert 49205-14 lid bumper, 3 or 4 places per lid.
- b. Install placard on bracket on top of lid.
 - i. Locate placard on bracket.
 - ii. Drill #30 through placard and bracket, using holes in placard.
 - iii. Remove placard and de-burr holes in placard and on bracket.
 - iv. Locate placard on bracket, and cleco in place.
 - v. Rivet placard with four CR3213-4-02 CherryMax rivets.
- c. Option: Install walkway on top of lid (lid must be fitted with walkway provisions)
 - i. Note: avoid touching surface of tread plate with bare hands to prevent smudges or marks on the top surface.
 - ii. Pull tread plate from stock. Shear tread plate to length.
 - iii. De-burr edges of tread plate with scotch-brite disc on die-grinder.
 - iv. Locate tread plate on lid. Hold tread plate in place with bags of lead shot.
 - v. Mark and drill #30 holes:
 1. 0.25" from edge of tread plate, centre on cross members (0.38")
 2. 0.25" from edge of tread plate, middle of each walkway stringer
 - vi. De-burr and counter-bore (if required to provide clearance of rivet head on checker pattern) all holes in tread plate using 1/4" piloted counter bore on both sides.
 - vii. De-burr holes in lid tubes.
 - viii. Apply bead of RTV silicone sealant along all tubes under tread plate.
 - ix. Set tread plate in place, secure with clecos if necessary.
 - x. Rivet placard with CR3213-4-02 CherryMax rivets
- d. Record PO/WO of all parts (including lid) used in steps above on attached material tracking list.

2. Body Assembly

ADOG

- a. Install attachment fittings
 - i. Carefully remove excess powder coat from around attachment lug threads using a countersink.
 - ii. Run 3/8-24 tap into attachment lugs to clear threads.
 - iii. Apply anti-seize compound to attachment fittings 96710-01 (alternate: Ancra 40088-14)
 - iv. Install attachment fittings with two NAS1149F0363P washers in four lugs in basket.
 1. 90610 (Robinson R44) basket only:
 - a. Install 1 fitting 906?? in lower forward attachment lug only.
 - b. Install 3 96710-01 fittings in remaining locations.
 - v. Torque to ??

- b. 946 Basket Only: Install Cutout Brace – *must be completed after hinge installation*
 - i. Locate 94621-01 Brace over aft cross tube cutout
 - ii. Install two AN4-6A bolts and two AN4-30A bolts with NAS1149F0463P washers.
 - iii. Torque AN4 bolts to ??
- c. Record PO/WO of all parts (including basket) used in steps above on attached material tracking list.

3. Hinge Installation

4006

- a. Prepare hinge.
 - i. Cut hinge to length:
 - 1. 776, 906 – 54"
 - 2. 751, 803 – 70"
 - 3. 698, 764, 945 – 72"
 - 4. 784 – 90"
 - 5. 940, 946, 959 – 95"
 - ii. Drill #30 pilot holes using hinge jig. For long hinges, flip at specified location on jig.
- b. Install hinge on basket
 - i. Locate hinge on basket (standard baskets)
 - 1. centre fore/aft
 - 2. 0.15" – 0.18" up from bottom edge
 - ii. Locate hinge on basket (extra wide baskets)
 - 1. centre fore/aft
 - 2. set hinge at 90 degrees (as if lid would be installed) using a small square, locate vertical side at 22.5" from outboard edge.
 - iii. Drill #30 through holes in hinge into basket rim. Cleco in place with 1/8 (copper) clecos.
 - iv. Drill holes up to #21 through hinge and rim. Replace 1/8 clecos with 5/32 (black) clecos.
 - v. Remove hinge and de-burr holes in hinge and basket rim.
 - vi. Cleco hinge to basket with 5/32 clecos.
 - vii. Install hinge with CherryMax rivets
 - 1. CR3523-5-02 monel rivets – last 2 rivets in each end
 - 2. CR3213-5-02 aluminum rivets – all other locations
- c. Install lid on basket
 - i. Locate lid on hinge (all baskets)
 - 1. center fore/aft
 - 2. 0.15" – 0.18" down from top edge
 - ii. Drill #30 through holes in hinge into lid rim. Cleco in place with 1/8 clecos.
 - iii. Drill holes up to #21 through hinge and rim. Replace 1/8 clecos with 5/32 clecos.
 - iv. Remove hinge and de-burr holes in hinge and lid rim.
 - v. Cleco lid to hinge with 5/32 clecos.
 - vi. Install hinge with CherryMax rivets
 - 1. CR3523-5-02 monel rivets – last 2 rivets in each end
 - 2. CR3213-5-02 aluminum rivets – all other locations

- d. Record PO of hinge and rivets on attached material tracking list.

4. Install Handle

ADD

- a. Install handle brackets.
 - i. Set 84267-01 handle bracket on provisions in hoops, 2 places.
 - ii. Install AN3-11A bolt, NAS1149F0363P washer (2), MS21044N3 nut. Two places per bracket, two brackets per basket.
 - iii. Torque AN3 bolts to ??.
- b. Install handle
 - i. Trim 36278-01R and 36278-01L springs to ensure end of spring does not extend past edge of handle bracket, approximately 1/8". Set springs over bushing of 84261-01 handle assembly.
 - ii. Grease two 36275-01 bushings with ???. Insert into bushings of handle assembly.
 - iii. Locate handle on basket lid. Insert AN3-12A bolt with NAS1149F0363P through bracket on lid and handle bushing on one end of handle.
 - iv. On other end of handle, hook spring over catch rivet on handle assembly and use spring tool to twist spring to catch arm on bracket on lid while inserting AN3-12A bolt with NAS1149F0363P washer through lid bracket and handle bushing.
 - v. At first end, remove bolt and repeat step iv.
 - vi. Install NAS1149F0363P washer and MS21044N3 nut on both AN3-12A bolts.
 - vii. Torque AN3 bolts to ??.
- c. Check handle
 - i. Operate handle to ensure handle does not bind and springs hold handle in.
 - ii. Snap handle into brackets to ensure handle locks.
- d. Record PO/WO of all parts used in steps above on attached material tracking list.

5. Install lid brace

ADD

- a. Locate 36280-01 lid brace on bushing in basket. Ensure brace is on forward end of basket as it will be installed on the helicopter.
- b. On lid end, insert AN970-3 washer into end of lid brace. Insert AN3-15A bolt with NAS1149F0363P washer through AN970-3 washer, lid prop, and lid bushing. Install NAS1149F0363P washer and MS21044N3 nut on bolt.
- c. On basket end, insert AN3-17A bolt with AN970-3 washer through lid prop and basket bushing. Install NAS1149F0363P washer and MS2144N3 nut on bolt.
- d. Ensure brace is seated on lip of bushings before tightening nuts.
- e. Torque AN3 bolts to ??
- f. Record PO/WO of all parts used in steps above on attached material tracking list.

CARGO BASKET ASSEMBLY - COMMON

Complete
(initial or SQA #)

AK

6. Final Inspection

Dual inspection by a different person than assembled the basket.

- a. Check for general condition and correct assembly:
 - i. Bolts are tight
 - ii. Rivets are installed correctly
 - iii. Handle operates correctly
 - iv. Lid brace operates correctly
- b. Check that PO/WO numbers have been recorded.

Work Order: _____

Material Tracking Sheet
Eurocopter AS350 / AS355
Long Basket Assembly

1 of 2

Date Opened: _____

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
			78410-01	Cargo Basket Assembly		
Step 1				<i>Lid Assembly</i>		
	1		78412-01	Basket Lid Assembly		
Step 1.a.	4		49205-14	Bumper	Argus Industries Bumper	1190
	A/R		--	Sealant	Commercial Silicone RTV sealant	
Step 1.b.	1		78427-01	Placard	0.063 Sheet, 6061-T6 Aluminum	SN 78461-51
	4		CR3213-4-02	Cherry Rivet		14032
Step 1.c. (option)	1		70405-01	Lid Step Modification		
	1		70405-04	Tread Plate	3003 Aluminum Tread Plate, 0.063"	13066
	A/R		CR3213-4-02	Cherry Rivet		14032
	A/R		--	Sealant	Commercial Silicone RTV sealant	
Step 2				<i>Basket Assembly</i>		
Step 2.a.	1		78411-01	Basket Body Assembly		
	4		96710-01	Fitting	Alternate: Ancra 40088-14	13042
	8		NAS1149F0663P	Washer		13084
Step 3				<i>Hinge Installation</i>		
	1		MS20001P4	Piano Hinge	90"	
	8		CR3523-5-02	Cherry Rivet		13026
	A/R		CR3213-5-02	Cherry Rivet		13026
Step 4	1		84255-01	<i>Handle Installation</i>		
Step 4.a.	2		84267-01	Bracket	Delrin, 3/4" Sheet	WO 2014-48
	4		AN3-11A	Bolt		14001
	8		NAS1149F0363P	Washer		14048
	4		MS21044N3	Nut		13083

Work Order: _____

Material Tracking Sheet
Eurocopter AS350 / AS355
Long Basket Assembly

2 of 2

Date Opened: _____

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
Step 4.b.	1		84261-01	Handle Assembly		
	2		36278-01	Spring (1 left, 1 right)	304 Stainless, 1/16" Dia Music Wire	13085, 13085
	2		36275-01	Bushing	Brass, 5/16" Dia	wo #2013-33
	2		AN3-12A	Bolt		13084
	4		NAS1149F0363P	Washer		+3084 m 14048
	2		MS21044N3	Nut		13083
Step 5				Lid Brace Installation		
	1		36280-01	Brace Assembly		wo # 2011-28
	1		AN3-15A	Bolt		13064
	1		AN3-17A	Bolt		13064
	2		AN970-3	Washer		12094
	3		NAS1149F0363P	Washer		14048
	2		MS21044N3	Nut		13083
Step 6				Inspection	None	

Work Order: 2014-55Material Tracking Sheet
Eurocopter AS350 / AS355
Extra Large Basket Handle Assembly

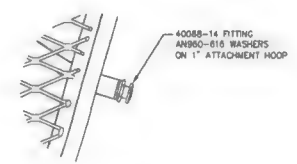
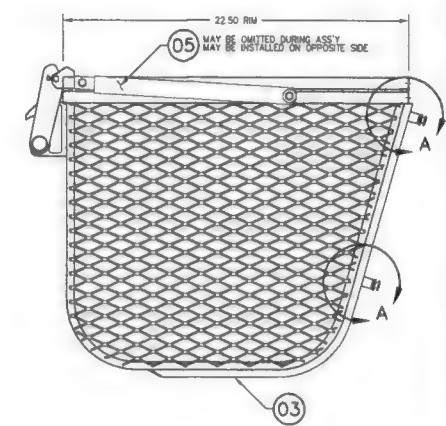
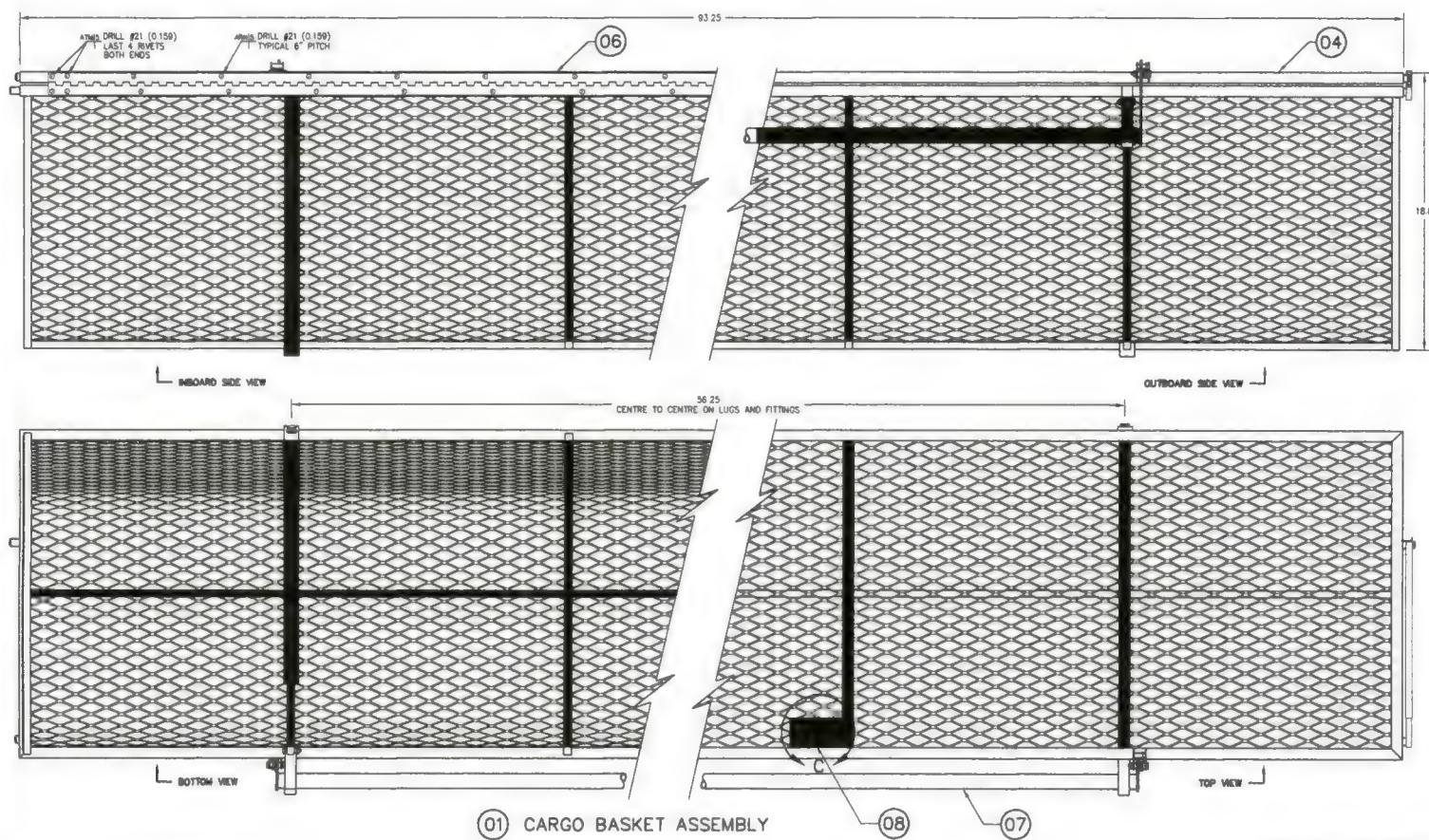
1 of 1

Date Opened: _____

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
		84261	84261-01	Handle Assembly		
Step 1				<i>Weld Lever Assembly</i>		
	. 2		84265-01	Lever	304 Stainless, 0.105 Sheet	2014-37
	. 2		36274-01	Bushing	304 Stainless, 7/16" x 0.065 Rnd. Tube	2014-37
	. 2		MS20615-4M3	Rivet		2014-37
	. A/R			Welding Rod	ER308L TIG Rod	14028
Step 2				<i>Clean Up</i>	None	
Step 3				<i>Fabricate Handle Bar</i>		
	. 1		36277-01	Handle Bar	316 Stainless, 1.0 x 0.065 Rnd. Tube	13077
Step 4				<i>Weld Handle Assembly</i>	None - Fuse weld, no rod req.	
Step 5				<i>Clean Up</i>	None	
Step 6				<i>Inspection - Final Assembly</i>	None	

2014-55

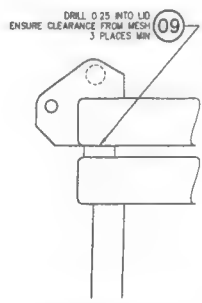
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0	INITIAL ISSUE		
1	CHANGED HANDLE CONFIGURATION, REMOVED ALTERNATE BASKET	BUC	27 JAN 10



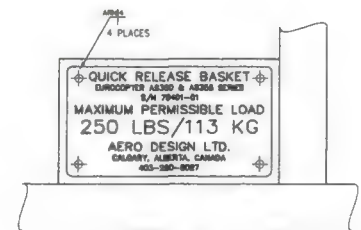
DETAIL A
SCALE 1 : 2
TYPICAL FRONT AND REAR

NOTE
1 ALL DIMENSIONS SHOWN ARE FOR REFERENCE ONLY. DIMENSIONS OF COMPONENTS AND COMPLETE ASSEMBLY ARE DETERMINED IN PREVIOUS STEPS

01 CARGO BASKET ASSEMBLY



BUMPER INSTALLATION
SCALE 1 : 1

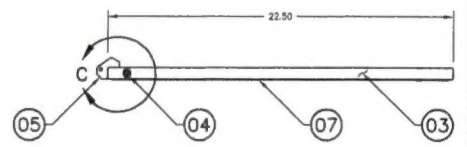
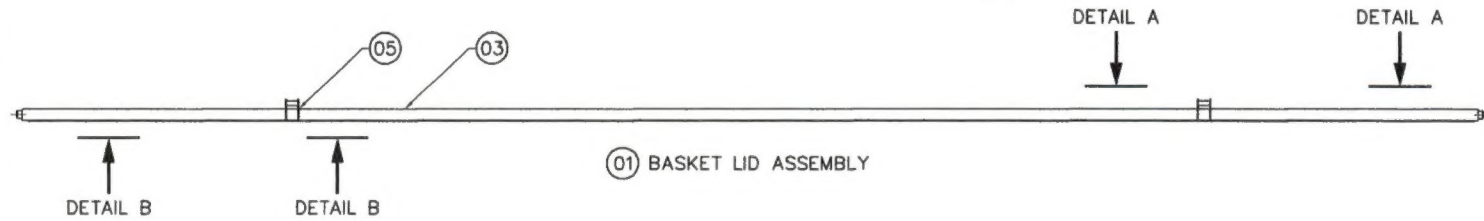
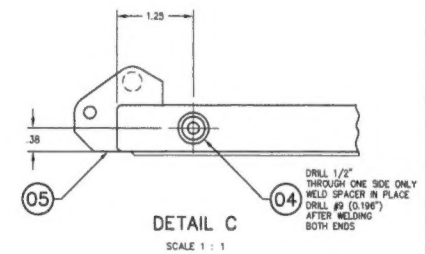
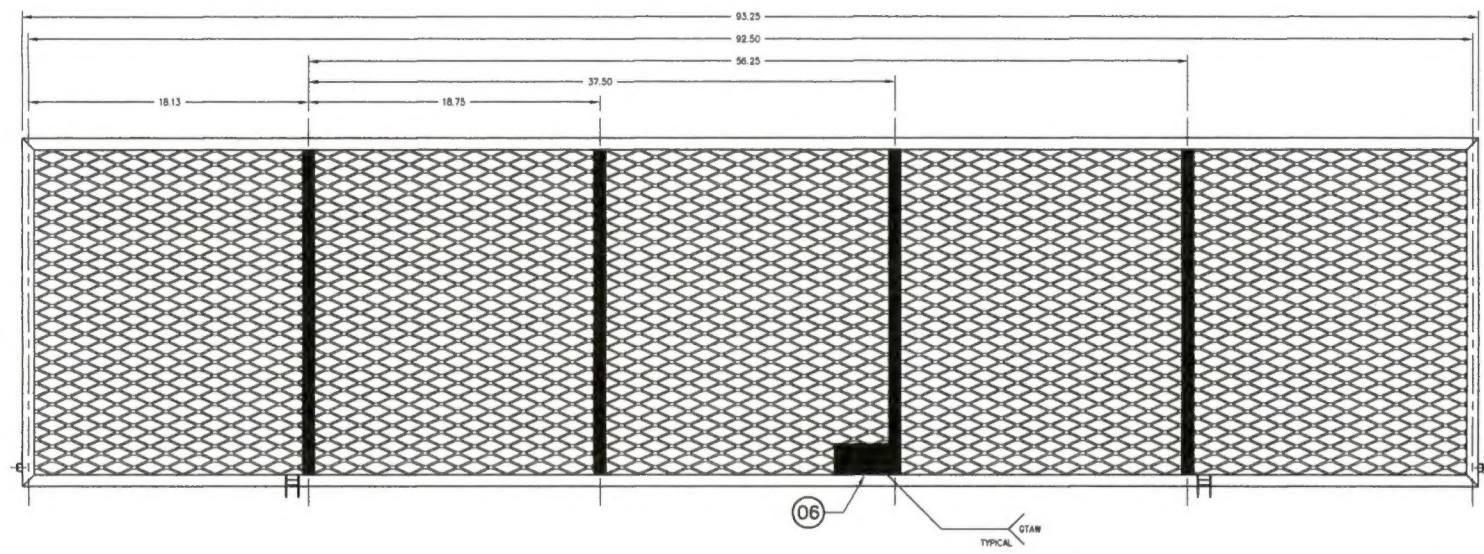


DETAIL C
SCALE 1 : 1
LOOKING AT PLACARD BRACKET

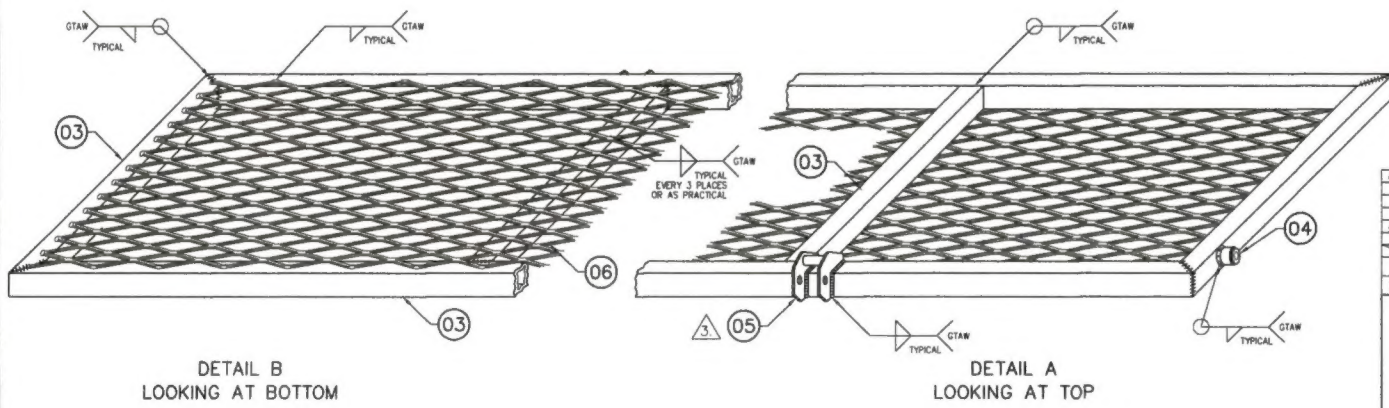
A/R	PART NO	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
4	40088-14	WASHER				
4	40088-14	FITTING				
8	CR3523-5-02	CHERRY RIVET				
A/R	CR3213-5-02	CHERRY RIVET				
4	CR3213-4-02	CHERRY RIVET				
3	49205-14	BUMPER				
1	78427-01	PLACARD				
1	84255-01	HANDLE BAR INSTALLATION				
A/R	MS2001P4	O6	PIANO HINGE			82 LONG
1	36280-01	BRACE ASSEMBLY				
1	78412-01	ON LID ASSEMBLY				
1	78411-01	O3	BASKET BODY ASSEMBLY			
02						
1	78410-01	O1	CARGO BASKET ASSEMBLY			
QTY						

BASIC CODE REF: HAS 523 C=COUNTERSUNK D=DIMPLE DIGIT# OF SHEETS TO BE DIMPLED DASH NO FOR DIAMETER N=MFD HEAD NEAR SOC F=MFD HEAD FAR SIDE DASH NO FOR LENGTH BASIC CODES BJ=M200470AD BB=M200426AD ARN=CR3213 ATM=CR3523		APPROVALS DATE DRAWN: R RATHWELL 19 FEB 08 CHECKED: E BURGOIN UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON DECIMALS ANGLES X XXX ±0.010 X XX ±0.03 X X ±0.1		AERO DESIGN LTD. CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 2908 2013 - 50TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 6R7 tel: (403) 250-8087 fax: (403) 250-8553 www.aerodesign.ca EUROCOPTER AS350 & AS355 SERIES QUICK RELEASE SKI BASKET ASSEMBLY SCALE 1 : 4 DWG SIZE DWG NO REV SHEET 1 OF 1 A1 78410 1	
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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	CHANGED HANDLE BRACKETS, REMOVE ALTERNATE LID	BUC	28 JAN 10



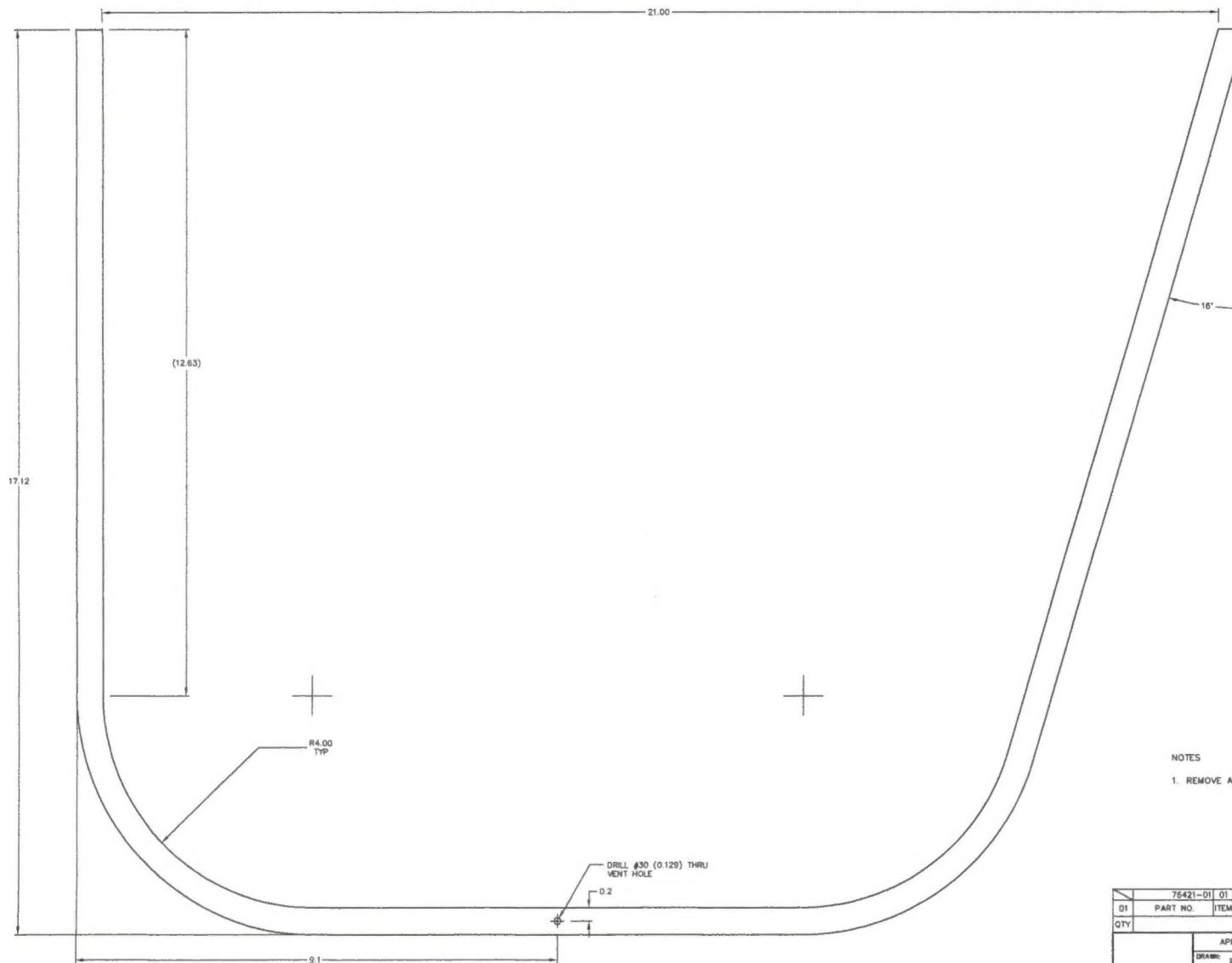
01 BASKET LID ASSEMBLY



- NOTES:
1. REMOVE ALL BURRS AND BREAK SHARP EDGES
 2. WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AWS 2685C.
 3. WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT.
 4. INSTALL ITEM 5 (HANDLE BRACKET ASSEMBLY) IN ACCORDANCE WITH AERO DESIGN LTD. DRAWING 36262 TYP 2 PLACES.
 5. WHEN ASSEMBLY IS COMPLETE, FILL ALL VENT HOLES WITH ROSETTE WELD.
 6. THOROUGHLY CLEAN AND POWDER COAT BASKET SUB-ASSEMBLIES PRIOR TO ASSEMBLY.

A/R	3/4-10F	07	MESH				
1	36204-10	08	PLACARD BRACKET				
1	84262-01	05	UPPER HANDLE BRACKET ASSY				
2	49216-01	04	SPACER				
A/R	03	02	SQUARE TUBE	4130 STEEL COND. N.	MIL-T-6736	3/4 X 0.035 SQR TUBE	
	78412-01	01	BASKET LID ASSEMBLY				
01	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE	
QTY	LIST OF MATERIALS						
APPROVALS				DATE			
DRAWN: R. RATHWELL				19 FEB 08			
CHECKED: E. BURGOIN							
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:							
DECIMALS				ANGLES			
X.XXX ±0.010				±1/2°			
X.XX ±0.03							
X.X ±0.1							
AERO DESIGN LTD.							
CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAB 290M 2013 - 39TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 0B7 Tel: (403) 856-8057 Fax: (403) 856-8053 www.aerodesign.ca							
EUROCOPTER AS350 & AS355 SERIES QUICK RELEASE CARGO BASKET BASKET LID ASSEMBLY							
SCALE 1 : 4				DWG. SIZE		DWG. NO.	
SHEET 1 OF 1				A1		78412	
						1	



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REV	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	TITLE BLOCK UPDATED; NOTE 2 REMOVED; ADD VENT HOLE	BJC	11/07/2014



NOTES

1. REMOVE ALL BURRS AND BREAK SHARP EDGES.

01 HOOP
SCALE 1 : 1

76421-01		01 HOOP		4130 STEEL COND. N		ML-T-8736		0.5 X 0.035 SQR TUBE					
QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE							
				LIST OF MATERIALS									
APPROVALS			DATE										
DRAWN: R. RATHWELL			24 JAN 08										
CHECKED: E. BURGON													
			AERO DESIGN LTD.										
			9886A MALASPINA ROAD										
			POWELL RIVER, BC, CANADA, V8A 0G3										
			TEL: 604 685.3276 www.aerodesign.ca										
			EUROCOPTER AS350 & AS355 SERIES										
			QUICK RELEASE CARGO BASKET										
			HOOP										
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS X.XXX ±0.010 X.XX ±0.03 X.X ±0.1						SCALE 1 : 1		DWG. SIZE		DWG. NO.		REV.	
						SHEET 1 OF 1		A1		76421		1	

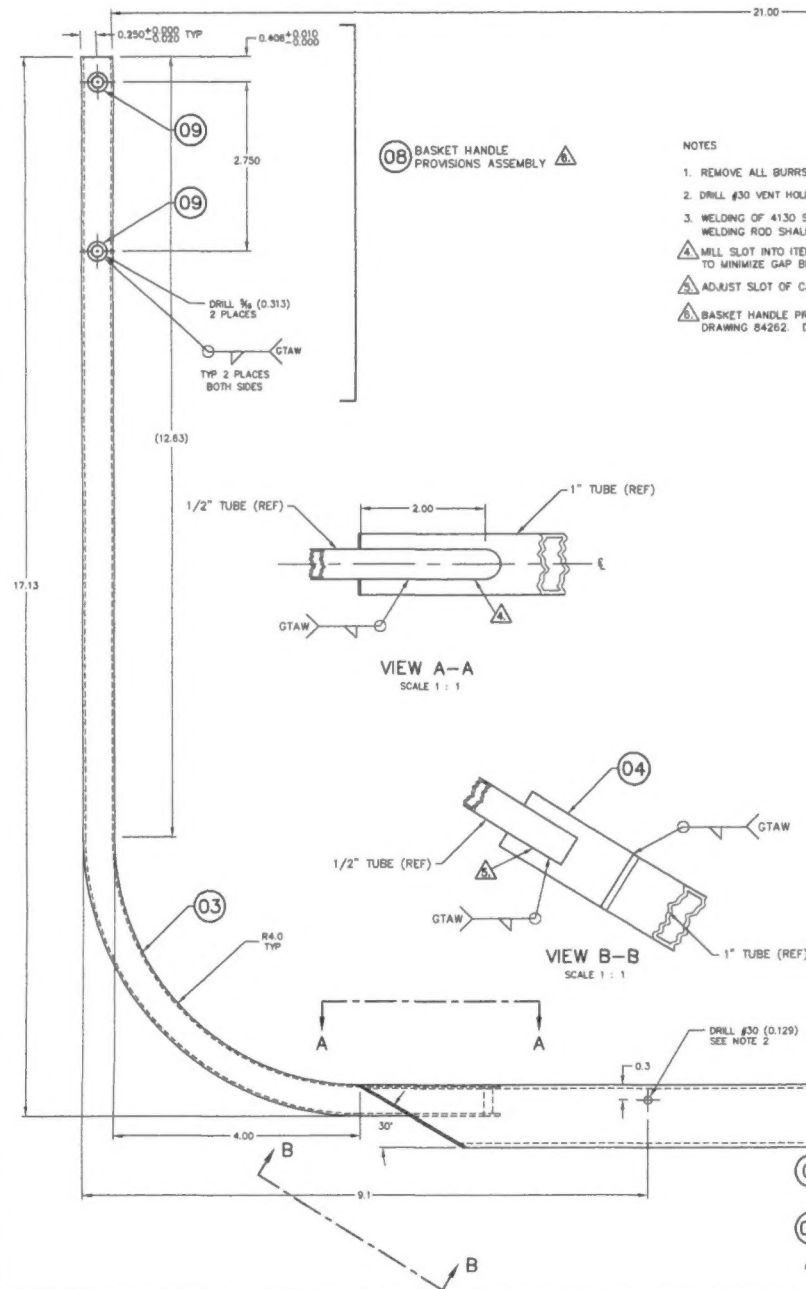


AERO DESIGN LTD.

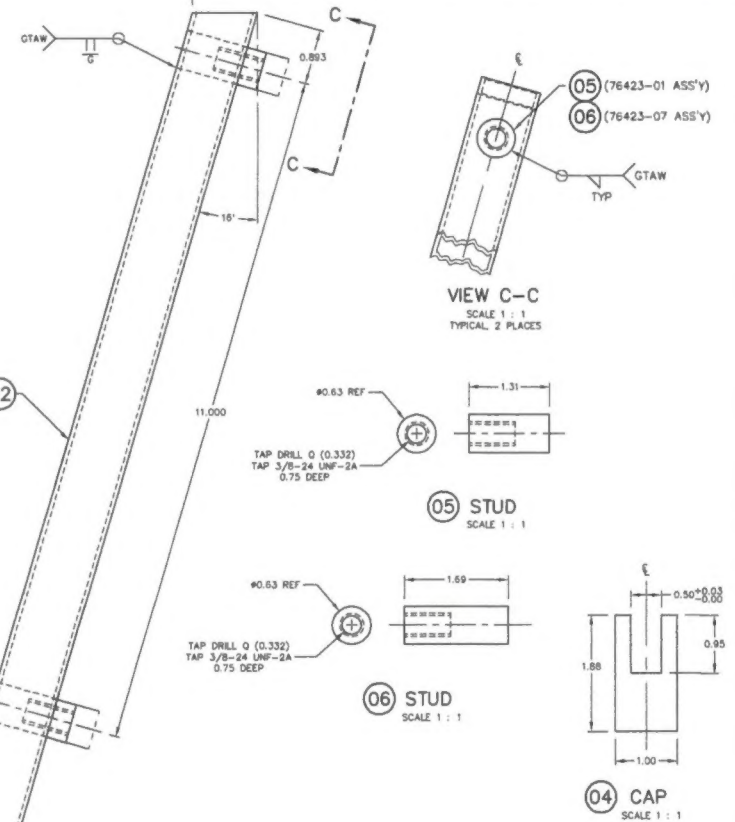
888A MALASPINA ROAD
POWELL RIVER, BC, CANADA, V8A 0G3
TEL: 804.483.3376 www.aerodesign.ca

EUROCOPTER AS350 & AS355 SERIES
QUICK RELEASE CARGO BASKET
HOOP


REV	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE	RR	24 JAN 08
1	ADDED 76423-07 ASSY AND 76423-06 PART	RR	05 MAR 09
2	CHANGED LENGTH OF STUD (ITEM 05)	BUC	18 JUN 10
3	TITLE BLOCK UPDATED; FORMAT UPDATED; LENGTH OF STUDS (ITEM 05 & 06) CAP (ITEM 04) UPDATED; HANDLE PROVISIONS (ITEM 06) ADDED	BUC	05/05/2014



1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
2. DRILL #30 VENT HOLE IN HOOP FOR VENTING OF WELD GASES.
3. WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AMS2685C. WELDING ROD SHALL CONFORM TO AMS ER70S-2 OR EQUIVALENT.
- ⚠ M11 SLOT INTO ITEM 1" TUBE AS SHOWN, CENTER END OF 1/2" TUBE TO MINIMIZE GAP BETWEEN 1" TUBE AND ITEM 1/2" TUBE.
- ⚠ ADJUST SLOT OF CAP (78423-04) TO FIT AS REQUIRED.
- ⚠ BASKET HANDLE PROVISIONS ARE INSTALLED IN ACCORDANCE WITH AERO DESIGN DRAWING 84262. DIMENSIONS AND PARTS SHOWN ARE FOR REFERENCE ONLY.



2	842622-01		09	BUSHING			
1	1	842623-01	08	BASNET HANDLE PROVISIONS ASSEMBLY			
	2	78423-01	08	STUD	MILD STEEL	ASIS 1010/1020	#0.63 ROD
	3	78423-05	05	STUD	MILD STEEL	ASIS 1010/1020	#0.63 ROD
	1	78423-04	04	CAP	MILD STEEL SHEET	ASIS 1010/1020	0.050 SHEET
	A/R	842623-01	03	1/8" TUBE 1/2IN	4130 STEEL COND. N	MIL-T-6756	0.5 x 2 CS SOR TUBE
	A/R		02	TUBE 1IN	4130 STEEL COND. N	MIL-T-6756	1 x 0.065 SOR TUBE
		78423-07	07	ATTACHMENT HOOP ASSEMBLY (USED ON 78411)			
		78423-01	01	ATTACHMENT HOOP ASSEMBLY			
08	07	01	PART NO	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
QTY	QTY	QTY			LIST OF MATERIALS		

APPROVALS		DATE		 AERO DESIGN LTD. 8888A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8B 0G3 TEL: 804-688-5215 www.aerodesignltd.ca
DRAWN: R. RATHWELL		24 JAN 08		
CHECKED: E. BURGIN				
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:				EUROCOPTER AS350 & AS355 SERIES QUICK RELEASE CARGO BASKET ATTACHMENT HOOP ASSEMBLY
DECIMALS		ANGLES		
X.XXX ±0.010		±1/2"		
X.XX ±0.03				
X.X ±0.1				
SCALE 1 : 1		DRG. SIZE	DRG. NO.	REV.
SHEET 1 OF 1		A1	76423	3

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	INCREASE LOAD TO 250 LBS / 113 KG	BJC	JAN 27/10

NOTES

- ENGRAVE 0.007 DEEP AS FOLLOWS:
"QUICK RELEASE BASKET" - 0.125 HIGH
"EUROCOPTER AS350 & AS355 SERIES" - 0.080 HIGH
"S/N 78401-XX" - 0.080 HIGH
"MAXIMUM PERMISSIBLE LOAD" - 0.125 HIGH
"250 LBS/113 KG" - 0.200 HIGH
"AERO DESIGN LTD." - 0.125 HIGH
"CALGARY, ALBERTA, CANADA" - 0.080 HIGH
"403-250-8027" - 0.080 HIGH

DRILL #30 (0.129)
4 PLACES



01 PLACARD

78427-01	01	PLACARD	6061-T6 ALUMINUM	QQ-A-250/11	0.063 SHEET
PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE

LIST OF MATERIALS

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	DRAWN: R. RATHWELL		18 FEB 08					
	CHECKED: E. BURGOIN				EUROCOPTER AS350 & AS355 SERIES QUICK RELEASE CARGO BASKET PLACARD			
	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2" X.XX ±0.03 X.X ±0.1							
SCALE 1 : 1		DWG. SIZE A1		DWG. NO. 78427		REV. 1		
SHEET 1 OF 1								